

Thursday, 22/01/2009 8:03:45 AM
Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BLADE FOLD ASSY WELDMENT
Job Number	: 45046		
Estimate Number	: 13503		
P.O. Number	:	Part Number	: PB674300109
This Issue	: 22/01/2009 S.O. No. :	Drawing Number	: B6743001 P.6
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 45045	Material	:
Written By	:	Due Date	: 28/02/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>MF 09-01-22</u>		
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)
Square Tubing
batch:- 44989

MF 09-03-02

2.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Square Tubing
batch:- 43073

MF 09-03-02

3.0	PB6743001201	Square Tubing
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
Square Tubing
batch:- 44990

MF 09-03-02

4.0	PB6743001203	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Square Tube
batch:- 411907x2

MF 09-03-02

5.0	PB6743001239	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Square Tube
batch:- 44986

MF 09-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 8:03:45 AM
User: Melanie Fauteux

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 45046

Part Number: PB674300109

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PB6743001235	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Outer Tube
batch: 341490=1 B 45260=1

MF 09-03-02

7.0	PB6743001229	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Outer Tube
batch: 345258K2 B 44489=1

MF 09-03-02

8.0	PB6743001213	Flanged Hook
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
Flanged Hook
batch: 41488

MF 09-03-02

9.0	PB6743001311	Restraint
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
Restraint
batch: 41502

MF 09-03-02

10.0	PB6743001277	Contoured Hinge Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Contoured Hinge Arm
batch: 41499

MF 09-03-02

11.0	PB6743001243	Handle Arm Extension
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Handle Arm Extension
batch: 43332

MF 09-03-02

12.0	D34409	Tube Detent Clip Base (Supersedes B67-43)
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Tube Detent Clip Base
batch: B 41456

MF 09-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: PB674300109

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D344013	Bracket (Supersedes B67-43001-273)
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bracket

batch: B 24013 x 1. B 411201

MF 09-03-02

14.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

** ensure no burn thru after welding in tube -235 and -229 only where bushing -265 ***

MF 09-03-16 2

15.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

BE 09-04-17 2

16.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/04/17 (x2)

17.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

in detail D, mask in between -311 prior to paint

mask 1.750" on the end of -243 prior to paint

mask inside of D3440-9 prior to paint

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 8:30AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00AM

MF 09-04-17 (x2)

18.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 09/04/17 (2)

19.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/4/17 SE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

②
D 09/04/20

Job Completion



NF 09-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

